



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6522A00231-W142AJ-

3T-3

Job Sheet 201036



Part No: RBW6522A00231-W142AJ-3T-3 Job Qty: 6 pcs

Part Name: Base Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/23/19

Job Tracking No:

Due Date: 10/7/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG RBW6522A00231-W142AJ-3T Rev 5 IPP Rev A 18.02.12 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	6 pcs	10/7/19	10/7/19	0.00	0.60	Bandsaw - 1		SL 19-9-23
110	SL-2500Y - 2 - B4B	6 pcs	10/7/19	10/7/19	1.00	3.00	SL-2500Y -1 - B4B		SL
120	QC 2	6 pcs	10/7/19	10/7/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		SL
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		

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				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130 NV5000 - 1 - B4B	6 pcs	10/7/19	1.00 1.50	NV5000 - 1 - B4B	19-09-20
				NV5000 - 2 - B4B	
140 QC 2	6 pcs	10/7/19	0.00 0.00	QC 2 - 1	
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	19-09-20
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
150 QC 8	6 pcs	10/7/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	

					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	B.P 19-10-02
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
180	Outsource - 4 - Anodize	6 pcs	10/7/19	0.00 0.00	ATG001	2019-10-4
190	Packaging 2-1 - Receive - B4B	6 pcs	10/7/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
						Plex 9/23/19 8:53 AM Dart.Renwick.Jennifer

200 QC 6	6 pcs	10/7/19	0.00 0.00	Packaging 2 - 36 - B4B	
				QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
210 Packaging 3-1 - Stock - B4B	6 pcs	10/7/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	6 pcs	10/7/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - (Bandsaw) Cut blanks to 1.42"

Descriptions: 110 - (MORI SL2500Y LATHE) 1-Machine as per folio FC551 FOLIO REV: AA DWG REV: 5 2-Debur

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - NV5000-1 (MORI SEIKI VERTICAL MACHINE #1) 1-Machine as per folio FC551 FOLIO REV: AA DWG REV: S 2-Debur

140 - (QC2- Inspect parts off machine FAI/FAIB) Engrave T/N and/or P/N number using Marktronic engraver as per DWG.

150 - (QC8- Inspect parts - second check)

180 - (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: 44694 -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required

190 - (Receive & Inspect for Damage & Mat'l Certs)

200 - (QC6- All purchased or subcontracted products)
210 - (Identify as per dwg & Stock Location: _____)
220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R6.250	6061-T6 Round Bar 6.250"	.7200 ft (.12 ea)	100-Bandsaw - 1	SO48557 = .72

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6R6.250	1	9	0

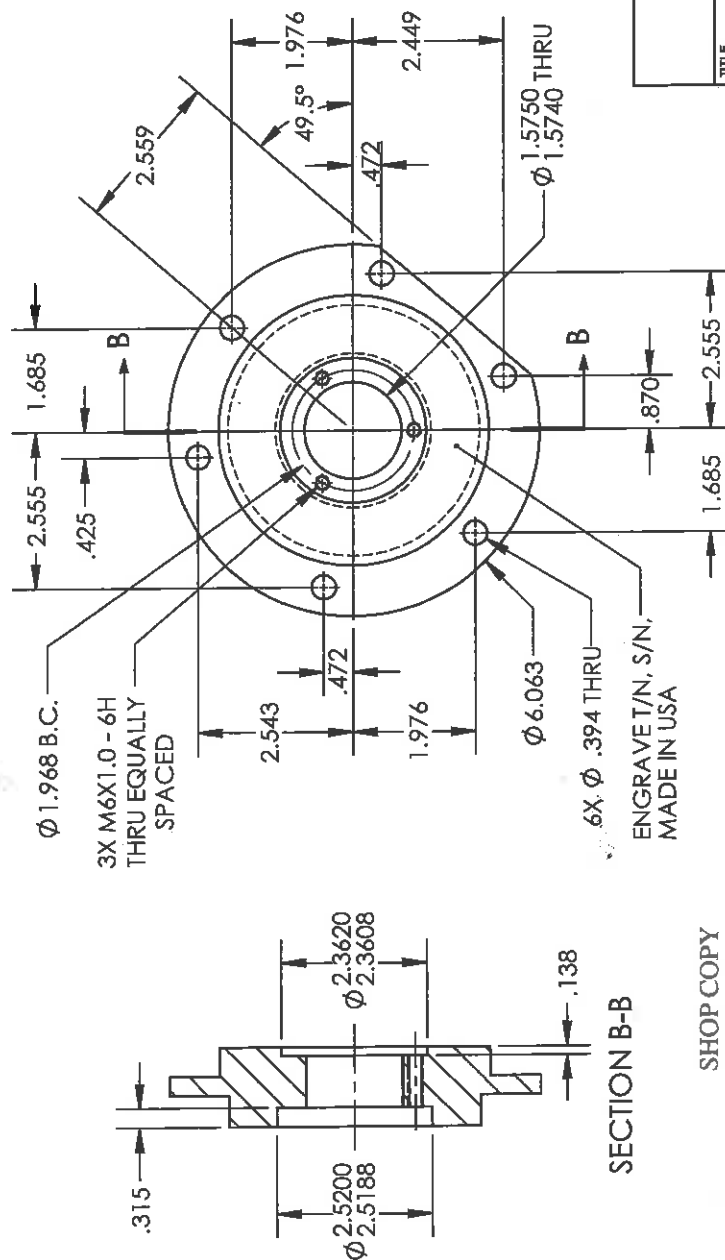
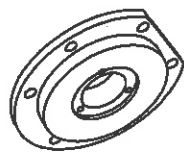
Part Specifications

Specifications could not be found.

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
4	16-0250	3 CHD DIM WAS Ø4.1340/4.1326 S Ø4.0920/4.0906 (P.F.-7).	12/5/2016
			SM
			JAG



TGB/SERVO ACTUATOR OIL
SEAL FIT/EXTRACTION TOOL

DWG NO. RBW6522A00231-W142AJ-3T-3 REV 5

MATERIAL: 6061	
TREATMENT: BLACK ANODIZE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
SPEC: MIL-A-8825, TYPE II, CLASS II	.XXX ± .005 FRACTIONS ± 1/8
DRAWN BY: PERRITT	.XX ± .01 ANGLES ± 5°
CHECKED: CLOUGH	.X ± .1 SURFACES ± 125
OPPS APPR: ANDERSON	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
	USED ON MODEL AW139
SCALE: 1:3	DATE: 10/5/2010
	SHEET 4 OF 10

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 201036

BASE PLATE



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐
Part No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐
		Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐
					Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042) _____	
Description Work Order Deviation		Disposition			
		Completed By _____			
		Lead hand / Supervisor _____			
		QC / QA Coordinator _____			
Root Cause		FAULT CATEGORY			
Operator ☐		Contamination ☐		Power Loss/Surge ☐	
Manufacturing Process ☐		Misaligned/off center ☐		Folio/Program ☐	
Equip/Tooling ☐		BOM/Route ☐		Grain Direction ☐	
Handling/Preservation ☐		Broken/Damage/Defect ☐		Weld ☐	
Material ☐		Incomplete/Unclear Instructions ☐		Wrong Stock Pulled ☐	
Product Improvement ☐		Drill Holes ☐		Out of Sequence ☐	
Process Improvement ☐		Fit/Function ☐		Off-set/Set-up ☐	
Human Factors ☐		Other/Details: _____		Positioned Wrong ☐	
				Outside Tolerance ☐	
				Drawing ☐	
				Finish ☐	
				Part Lost/Missing ☐	
				Misread ☐	

DART AEROSPACE LTD	Work Order: 201036
Description: Base plate	Part Number: RBW6522A00231-W142A1-3T-3
Inspection Dwg: RBW6522A00231-W142A1-3T-3 Rev: 5	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
315	± .005	318	✓		VERV X-2	
2.520	+0 - .0012	2.5194	✓		go-mago	
138	± .005	139	✓		VERV	
2.362	+0 - .0012	2.3614	✓		go-mago	
1.575	+0 - .001	1.5745	✓		mic JL-11	
315	± .005	315	✓		VERV	
472	± .005	472	✓		"	
4.409	± .005	4.409	✓		mic JB-06	
1.300	± .005	1.305	✓		VERV	
4.092	+0 - .0014	4.0916	✓		mic JB-06	
4.760	± 0.005	4.760	✓		Caliper	JCL -08
6.063	± 0.005	6.062	✓			
2.559	± 0.001	2.559	✓			
0.08 x 30°	± 0.010	.077	✓			
.475	± 0.005	.477	✓		H.G.	31006
2.543	± 0.005	2.542	✓			
1.685	± 0.005	1.684	✓			
1.976	± 0.005	1.976	✓			
1.683	± 0.005	1.686	✓			
1.976	± 0.005	1.977	✓			
Ø .393	+0.005 -0.001	0.396	✓			
M6 x 1.00	6H	0.7.	✓		60-ND-60	
.395	± 0.005	.395	✓		Caliper	JCL -08
.433	± 0.005	.434	✓			

Measured by: J. C. L.	Checked by: B. C.	QC Inspector:
Date: 19-9-23	Date: 19-10-02	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044694**



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044694

PO Date: 10/4/19

Due Date: 10/16/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	201036-A	RBW6522A00231-W142AJ-3T-3	RBW6522A00231-W142AJ-3T 5	Base Plate (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed XI	-	10/21/19	1 pcs	0 pcs	1 pcs	\$5.51/pcs	\$5.51
	201036				Firmed	-	10/22/19	5 pcs	0 pcs	5 pcs	\$5.51/pcs	\$27.55
Sub Total:								6	0	6		\$33.06
2	181397	647.1814	647.1800	Gusset LH : Various STC's ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)	Firmed	-	10/16/19	16 pcs	0 pcs	16 pcs	\$8.76/pcs	\$140.16
3	201205	SWA3-300	SWA3-300 3	Wire Clamp (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 3 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	10/16/19	30 pcs	0 pcs	30 pcs	\$5.52/pcs	\$165.60



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K8A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB044694



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	199122	RBT18608-2	RBT18608 2A	Weldment -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	10/16/19	10 pcs	0 pcs	10 pcs	\$5.51/pcs	\$55.10
5	199132	RBW6522A00231-W142S-3T	RBW6522A00231-W142S-3T 2	Tail Rotor Gear Box/Mast Output Oil Seal Assembly Support Tool (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Received	-	10/16/19	5 pcs	5 pcs	0 pcs	\$5.51/pcs	\$0.00
Grand Total:												\$393.92

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an Integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/21/19 1:53 PM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918812

Date: 21-Oct-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577		Fax: 613 632-1000	
Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
1 ea	Part: RBW6522A00231-W142AJ-3T-3 Base Plate Black Anodize per MIL-A-8625F, Type II, Class2, Water Sealant .0004-.0010" (4 - 1 mils). Job: 26267 PO: POHB044694		Rev: 5 Line: 1
16 ea	Part: 647.1814 Gusset LH Hard Black Anodize per MIL-A-8625, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 9731-F-J19 Job: 26268 PO: POHB044694		Rev: A Expiry Date: 06/20 Line: 2
30 each	Part: SWA3-300 Wire Clamp Anodize per MIL-A-8625F, Type II, Class2, Black, .0004-.0010" (4 - 1 mils). Water Sealant Job: 26269 PO: POHB044694		Rev: 3 Line: 3
5 ea	Part: RBW6522A00231-W142S-3T Tail Rotor Gear Box/Mast Output Black Anodize per MIL-A-8625F, Type II, Class2, Water Sealant .0004-.0010" (4 - 1 mils). Job: 26271 PO: POHB044694		Rev: 5 Line: 5
Made in Canada.			

DAS
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OCT 21 2010

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OCT 21 2019



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918812

Date: 21-Oct-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms

Ship Via

ATG Delivery

Quantity

Description

CERTIFICATE OF CONFORMANCE
A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements.

Date:

OCT 21 2019

Certified Signature: _____

Receiver Signature: _____

A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited.

Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.



Made in Canada.